1,361,411													
Work Orde Monday, May 30													Page 1
Item ID:	D3195-041			1	Accept						Setup S	tart	
Revision ID:							EL MIN ERSEC MULLI DA	113 20 (() 8(8)) 88(
Item Name:	Bracket Assemi	bly	1								S	Stop	
Start Date:	5/30/2011	Start Qty: 4.0	60				Cust Item	ID•					
Required Date:	6/10/2011	Start Qty: 4.0 Req'd Qty: 4.0	o 6 °		•	1	Customer:						
Reference:		•		1 12-11/1 5(8) (82)									
Approvals:	Process Plan	1: MF	Date: _/	1-05-30	Tooling:		D	ate:	_	I		tart	
	QC:	?	Date:		SPC (Y/N):	· .		ate:			S	Stop	
Sequence ID/ Work Center ID		Operation Description			Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	t Rejec Numt	sp. amp
Draw Nbr	Revi	sion Nbr											
D3195	Rev	A										•	
		BAND SAW			0.00							11 21 31 31	
Bandsaw		Memo			0.00	1	1			18	-		
Jeaspa Bandsaw		Cut blan	nks: (0.75" x 2.00	") x 3.60" long	ント	11/06	101		(6			
		•											
110		HAAS CNC VERTI	CAL MACHININ	[G #1	0.00						,	•	
HAAS 1		Memo			0.00			1 .		6			

120

HAAS CNC vertical machine #1

QC2- Inspect parts off machine FAI/FAIB

0.00

Machine D3195-1 as per Folio FA334 and Dwg D3195□Identify as D3195-1□Deburr

Memo

0.00

Quality Control

	TOSPACE			WORK OPPER	OHANOEO				
W/O:				WORK ORDER	CHANGES				
DATE	STEP		PROCEDU	RE CHANGE	В	y Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):		PAR #: Fa	ult Category:	NCR: `	Yes No D	QA:	Date: _	
	R	esolution:	D	sposition:	QA: N/	C Closed:		Date: _	
				 					

NCR:	WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		C	Corrective Action Section B		Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng		Action Description Chief Eng		Section C	Chief Eng	QC Inspector	
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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 70	1146
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Monday, May 30, 2011 11:22:01 AM



Page 2

Item ID:

D3195-041

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Bracket Assembly

5/30/2011

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Date:

Tool # Plan

Code

Start Stop



Required Date: 6/10/2011

QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Accept

Qty

Reject Qty

Reject Number

Insp. Stamp

Sequence ID/ **Work Center ID**

130

QC

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

0.00

0.00

B. A 11/06/02

Run

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

6 6 Il 1/00/03

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

□OVEN TEMPERATURE:

323 of FINISH TIME:

6x 8 M-f 11/06/06

M115128

Dart Aeı	rospace	e Ltd								
W/O:				W	ORK ORDER CHAN	GES				
DATE	STEP	PRO	CEDUF	RE CHA	ANGE		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		,			· ·					
Part No: PAR #: Fa				ult Category: NCR:			: Yes N	lo DQA:	Date: _	
	R	esolution:	Dis	positio	on:	QA:	N/C Clo	sed:	Date: _	
NCR:		\	VORK	ORE	ER NON-CONFORM	MANCE	(NCR)	*		
DATE STEP		Description of NC		Corrective Action Initial Action Descrip		Section B on Sign &		Verificatio		Approval
		Section A		f Eng	Action Description Chief Eng	•	Date	Section C	Chief Eng	QC Inspector

iton.										
		Description of NC			Corrective Action Section B		Verification	Approval	Approval	
DATE	STEP	Section A Inp		tial f Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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NOTE: Date & initial all entries

Work Order ID 70146

Monday, May 30, 2011 11:22:01 AM



Page 3

Item ID:

D3195-041

Accept



Setup Start

Stop

Revision ID:

Item Name:

Bracket Assembly

Start Date:

5/30/2011

QC:

Start Qty: 4.00

Required Date: 6/10/2011

Req'd Qty: 4.00



Date:

Cust Item ID:

Customer:

Reference:

A	Di	Dr	O.	va	ls	:

Process Plan:

Date:

Tooling:

Date:

Run

Sequence ID/ **Work Center ID**

160

QC

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

SPC (Y/N):

0.00

0.00

Date: Tool ID

Tool # Plan Code

Accept Qty

Reject Oty

Start

Stop

Reject Insp. Number Stamp

BK 11-6-6

170

Small Fab

Small Fab

Small Fab

Memo

Memo

0.00

0.00

1-Lightly Sand bonding surface 2-Bond D3195-5 into D3195-1 as per Dwg D3195 A/RContact Cement 1//095

180

Quality Control

QC5- Inspect part completeness to step on W/O

W/O:				W	ORK ORDER CHANGES											
DATE	STEP	PRO	CEDUF	RE CH	ANGE	Ву	By Date Qty Approval Chief Eng / Prod Mgr									
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Part No	:	PAR #:	l		egory: N											
	R	esolution:			on: Q				Date:							
NCR:		\	WORK	OR	DER NON-CONFORMANC	E (NCR	()									
DATE	STEP	Description of NC	In	tial	Corrective Action Section B Action Description	Sign &		cation	Approval	Approval						
		Section A		f Eng	Chief Eng	Date	Sect	ion C	Chief Eng	QC Inspector						
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NOTE: Date & initial all entries

Work Order ID 70146

Monday, May 30, 2011 11:22:01 AM



Page 4

Item ID:

D3195-041

Accept

Setup Start

Revision ID:

Item Name:

Bracket Assembly

Start Date:

5/30/2011

Start Oty: 4.00

Rea'd Otv: 4.00

Operation

Description



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Stop



Required Date: 6/10/2011

QC:

Date: _____

SPC (Y/N):

Set Up/

Date:

Tool # Plan

Accept

Reject Oty

Insp.

190

Sequence ID/

Work Center ID

Packaging

Packaging

Memo

0.00

0.00

Run Hours

Code Qty

Reject Number

Stamp

200

QC **Quality Control** OC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location 24 CA

0.00

Memo

0.00

W/O:				N	ORK ORDER CHANGES	S					
DATE	STEP	PRO	CEDURE	Е СН	ANGE	Ву		Date Q	ty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		*									
Part No	•	PAR #:	Faul	t Ca	tegory:	NCR: Ye	s No	DQA: _		_ Date: _	
	R	esolution:	Disp	osit	ion:	QA: N/C	Clos	ed:		Date:	
NCR:		V	WORK (OR	DER NON-CONFORMAN	ICE (NC	R)		·		
DATE	STEP	Description of NC Section A	Initia Chief E		Corrective Action Section Action Description Chief Eng	B Sigr Da		Verification C		Approval Chief Eng	Approval QC Inspector
											-

NOTE: Date & initial all entries

Picklist Print

Monday, May 30, 2011 11:21:58 AM

Work Order ID: 70146

D3195-041

Parent Item Name: Bracket Assembly





Start Date: 5/30/2011

Required Date: 6/10/2011

Page 1

Start Oty: 4.00

Loc Code

Required Oty: 4.00

C٥	m	m	4	ní	ŀc	٠

Parent Item:

IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3195-5		Manufactured	No			100	Each	6.0000	1	4	11/06	/06	
				Location		Loc	<u>Qty</u>	Loc Code				•	
				ST042			6	*					•
					69384		6			6			
M6061T6B0.750X02.00 0		Purchased	No			170	f	27.7650	0.3	1.26315	8		
										. JL 1	1/06/01		

(0/1 T/D 750	2.00	

6061-T6 Bar .750 x 2.00

Location Loc Qty MAT003 27.765 100742 7.035 111448 20.73

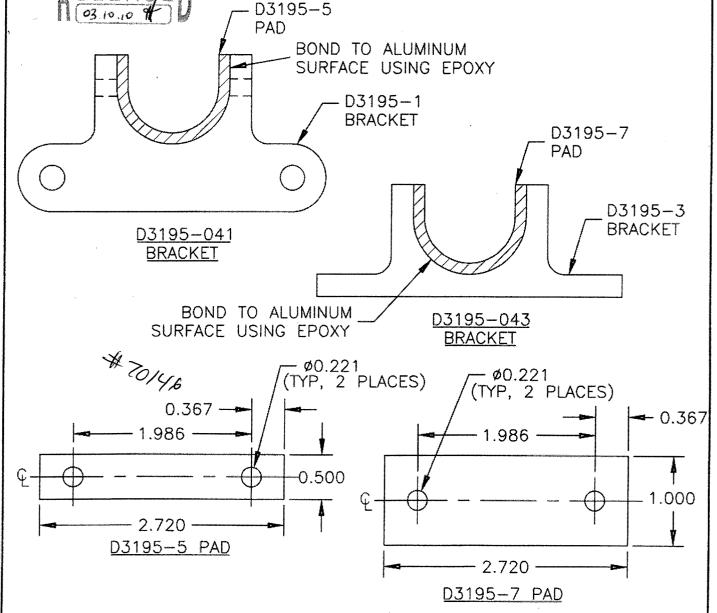
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W/O:				V	ORK ORDER CHANGES					
DATE STEP PROCE		CEDU	RE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								}		
	}									
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		·								
Part No	•	PAR #:	Fa	ult Ca	tegory:N	CR: Yes	No DQ	4 :	_ Date: _	
	R	esolution:	Di:	 sposit	ion: Q	A: N/C C	losed:		Date: _	
NCR:		\	WORK	OR	DER NON-CONFORMANC	E (NC	R)			
DATE	STEP	Description of NC			Corrective Action Section B	T-6:	Verific	ation	Approval	Approval
DATE	SIEP	Section A		itial ef Eng	Action Description Chief Eng	Sign Date	I Occu	on C	Chief Eng	QC Inspector
									: 1	

NOTE: Date & initial all entries





DESIG	" P	DRAWN BY		AEROSPACE LTD KESBURY, ONTARIO, CANADA
CHEC	(ED A	APPROVED ,	DRAWING NO.	REV. A
	71	94	D3195	SHEET 1 OF 3
DATE			TITLE	SCALE
 03.0	6.23		BRACKET	1:1
Α		03.06.23	NEW ISSUE	



D3195-5 & D3195-7 PAD

- MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK (POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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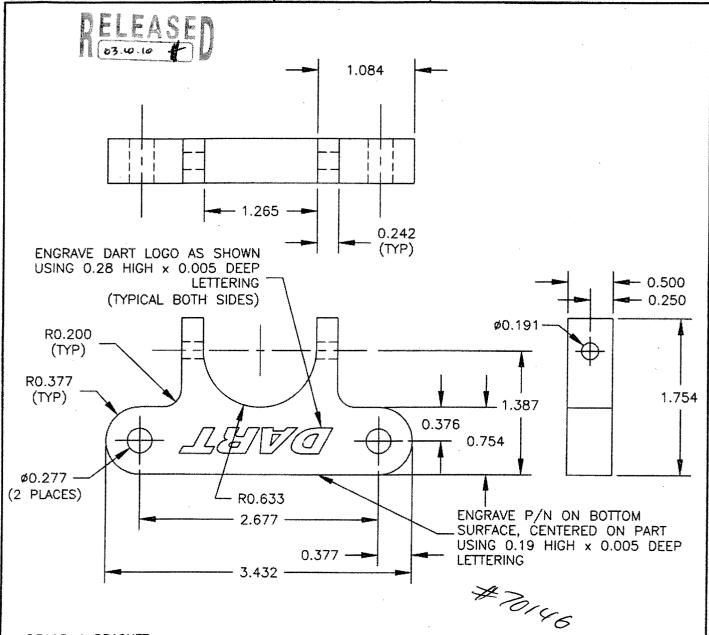
Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHA	NGES					
DATE	STEP	PROCEDURE CHANGE By Date Qt				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								-		
Part No	:	PAR #:	Fault Cat	tegory:	NC	R: Yes 1	No DQA:		Date:	
	R	esolution:	Disposit	ion:	QA	: N/C Clo	sed:		Date:	
NCR:		V	VORK ORI	DER NON-CONFO	RMANCE	(NCR)				
DATE	OTED	Description of NC	Corrective Action Initial Action Descript Chief Eng Chief Eng		Section B		Verification Section C		Approval	Approval
DATE	STEP	Section A			on Sign & Date				Chief Eng	QC Inspector
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DATE			TITLE		SC.	ALE
03.06.2	3		BRACKET			1:1



D3195-1 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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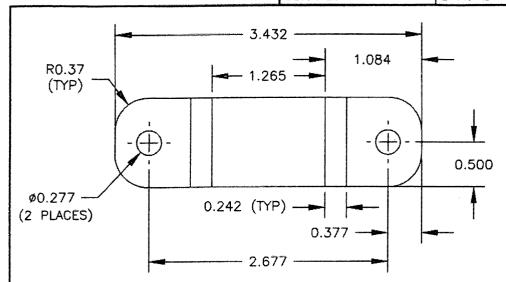
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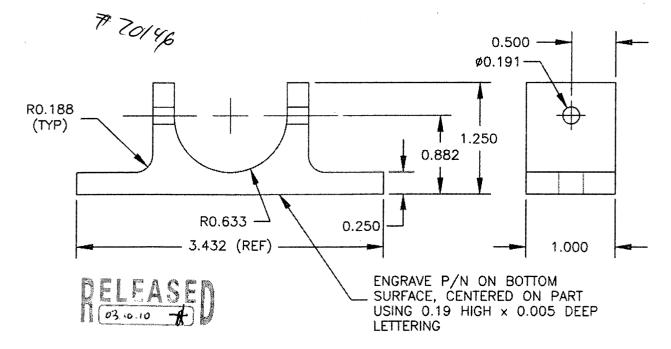
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W/O: WORK ORDER CHANGES	
DATE STEP PROCEDURE CHANGE By Date	Qty Approval Chief Eng / Prod Mgr Approval QC Inspector
	T Tod Nigi
Part No: PAR #: Fault Category: NCR: Yes No DQA	Date:
Resolution: Disposition: QA: N/C Closed:	Date:
NCR: WORK ORDER NON-CONFORMANCE (NCR)	
DATE STED Description of NC Corrective Action Section B Verifica	ation Approval Approval
DATE STEP Description of NC Section A Initial Action Description Sign & Date Section	
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#	1	D3195	SHEET 3 OF 3
DATE		TITLE	SCALE
03.06.23		BRACKET	1:1





D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B)
- BREAK ALL SHARP EDGES 0.005 TO 0.010
- FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- TOLERANCES ARE PER DART QSI 018 UNLESS ÓTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		`	W	ORK ORDER CH	ANGES					
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	tegory:	N	CR: Yes	No DQ	A :	Date: _	
	R	esolution:	Disposit	ion:	Q	A: N/C CI	osed:		Date: _	
NCR:		V	ORK ORI	DER NON-CONFO	RMANC	E (NCF	?)			
DATE	OTED	Description of NC		Corrective Action	Section B	•	Verifi	cation	Approvai	Approval
DATE	STEP	Section A	Initial Chief Eng	tion Sign & Date		n & Section C		Chief Eng	QC Inspector	
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38										

DART AEROSPACE LTD	Work Order: ~	70146
Description: Bracket	Part Number:	D3195-1
Inspection Dwg: D3195 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First	Article	Protot	ype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.265	+/-0.010	1-262	/		vein 12-3	·
0.242	+/-0.010	.244				
1.084	+/-0.010	1.086				
R0.200	+/-0.010	,200				
R0.377	+/-0.010	-344	/			
Ø0.277	+0.005/-0.000	,218				
2.677	+/-0.005	2.1277	/			
3.432	+/-0.010	3.432	/			
0.754	+/-0.010	:454				·
1.387	+/-0.010	1.38				
0.500	+/-0.010	.499				
0.250	+/-0.005	.249	/			
1.754	+/-0.010	1.755	/			
Ø0.191	+0.005/-0.000	.192			1	
						W

Measured by:	JL.	Audited by:	B.A	Prototype Approval:	N/A
Date:	11/06/08	Date:	11/06/02	Date:	N/A

	Rev	Date	Change		Revised by	Approved
Γ	Ā	04.04.20	New Issue	(P/O D412-702-011/-13)	KJ/RF	74
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PROCEDURE CHANGE	Rv			Annroyal	
	By Date Qty			Approval Chief Eng / Prod.Mgr	Approval QC Inspector
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Part No:		_PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Close	d:	Date:

NCR:		•	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A		Corrective Action		Section B		Ammunud	Approval	
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